: BUSHING

: D2652

: NIA

: 10/28/2006

: N/A

D2652 REV A

Wednesday, 10/11/2006 12:49:29 PM

Hser.

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 28933

P.O. Number

: 10725

: NM

This Issue

Prsht Rev.

: 10/11/2006

First Issue **Previous Run**

: NIA

: 28693

Type

: MACHINED PARTS

S.O. No. : NIA

Checked & Approved By

Comment

Written By

: Est Rev:B

Now machined in house.

NG

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M303R0500

303 Round Bar 0.500"

Comment: Qty.:

0.0578 f(s)/Unit Total:

11.5500 f(s)

Material:303 ss .500" Round Bar

(M303R0500)

Batch: <u>M101448</u>

253

Each

2.0

HARDINGE CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

MS OLDIOLIS 253

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS Oblidis 253

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

PACKAGING RESOURCE #1

06/10/16 4253

5.0

PACKAGING 1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

BO6/10/18

Dart Ae	rospace L	td								
W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									·	
Part No	:	PAR #:	Fault Cate	gory:	NC				<u>`</u> Date: <u>⊘</u> _ Date: _	
NCR:			WORK ORD	ER NON-CONFO	RMANCE	(NCR)		·	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B	Sign & Date		cation ion C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date:

Wednesday, 10/11/2006 12:49:29 PM

:User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 28933

Part Number: D2652

Job Number:



Comment: FINAL INSPECTION/W/O RELEASE

Seq. #:

Job Completion

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE







U D610.18

Dart Aerospace Ltd

Dait Ac	rospace	Ltu							
W/O:)d	WC	ORK ORDER CHANGES	3				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-	
		4.			Ģ.				
		3						:	
								(2)	
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	_ Date: _	
					QA: N	/C Closed	d:	Date:	
NCR:		V	ORK ORDI	ER NON-CONFORMAN	CE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval
———	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28933	
Description: Bushing	Part Number:	D2652	
· · · · · · · · · · · · · · · · · · ·			
Inspection Dwg: D2652 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype	
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	.597	سا			
0.060	+/-0.005	.057				
Ø0.305	-0.002/+0.000	302				
Ø0.191	+0.005/-0.000	Ø.194				
Ø0.500	+/-0.010	Ø500				
0.030 x 20°	+/-0.010	,030	<u></u>			
R0.010	+0.010/-0.000	.010.				
141						

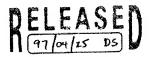
Measured by:	MS	Audited by:	En	Prototype Approval:	N/A
Date:	06/10/15	Date:	06/10/16	Date:	NIK

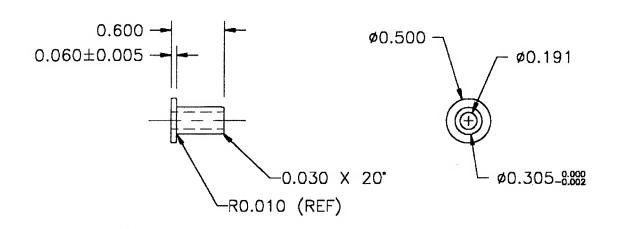
Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	- 14





	DESIGN	DRAWN BY	DART AEROSPACE USA, II FAIRCHILD INTERNATIONAL AIRPORT, WA	VC.
	CHECKED	APPROVED	DRAWING NO.	REV. A
,	BW	0101	D2652 SHEET	1 OF 1
	DATE		TILE	SCALE
	97:03:25		BUSHING	1:1





MATERIAL: AISI 303 SS

ISI 303 SS

SHOP COPY RETURN TO

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX RETURN TO TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NEWSERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

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